

Ship May 4<sup>th</sup>

Work Order ID 81299

\*81299\*

Page 1

March-12-12 4:42:47 PM

Item ID: D350-591-312

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step, Long RH

Start Date: 12/03/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/13 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

5 5 rclstol

MLJ 12-4-30

110

0.00

\*110\*

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

3-Grind End Plate flush

114785  
120169

10  $\phi$  12.04.17

Ac 12.04.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



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**\*10\***

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Required Date: 04/05/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				(X10)	Ø		12.04.23
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
180		0.00				(X10)	Ø		12.04.24
<b>*180*</b>									
Large Fab	Large Fab	0.00							12.04.23
Large Fab	Memo								
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding →								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod <u>M119785</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

**\*190\***

QC

Memo

0.00

8/7/12/5

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

8/7/12/5

Quality Control

X10

RH

210

Chemical Conversion Coat per QSI005 4.1

0.00

**\*210\***

HandFinish

Memo

0.00

Hand Finishing

⑩ 7/6 12-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*10\*

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 10.00

\*10\*

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*220*									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 12-15	0.00							
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 12-45								
230	Wing Walk as per dwg QSI005 4.4 Batch 121121	0.00							
*230*									
HandFinish									
Hand Finishing									
	Memo								
		0.00							
240	QC3- Inspect Part Finish	0.00							
*240*									
QC									
Quality Control									
	Memo								
		0.00							

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Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00				(10)			12/8/30-SP
<b>*250*</b>									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>						(410)			
QC	Memo	0.00							
Quality Control									
270		0.00							
<b>*270*</b>									
Packaging	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location:								

Rev B

12-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

**\*280\***

QC

Memo

0.00

Quality Control

12/5/2012

H/205-2

W/O:		WORK ORDER CHANGES					
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\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

## Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	10.0000	1	10		12 04 14	
*D3272-1*									**			12 04 14	
Step													

Location	Loc Qty	Loc Code
ST	381313	-10
WA	381313	20
	80178	10

~~10~~  
10

D3067-1  
\*D3067-1\*  
End Plate

Manufactured No

110 Each 178.0000

\*\*

12.04.17

Location	Loc Qty	Loc Code
WA	152	
	78608	92
	80881	60
WA016	26	
	67582	2
	68214	1
	79607	23

10

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3219-1

Manufactured No

110

Each

80.0000

2

20

\*D3219-1\*

\*\*

Plate

Location	Loc Qty	Loc Code
WA016	80	
73410	12	
77674	6	
78763	62	

12.04.17

20

D3066-1

Manufactured No

180

Each

66.0000

2

20

\*D3066-1\*

\*\*

Spacer

Location	Loc Qty	Loc Code
WA	66	
78605	66	

B81968 (20) Ae 12.04.23

MS20600-AD4W4

Purchased No

180

Each

2,478.000

16

160

\*MS20600-AD4W4\*

\*\*

Rivets

Location	Loc Qty	Loc Code
ST321	2473	
116188	59	
117364	253	
117601	200	
117885	195	
118840	1089	
119860	30	
119883	155	
120308	72	
120769	420	
WA018	5	
116712	5	

M121340 (160) Ae 12.04.23

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\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3065-041

Manufactured No

180

Each

44.0000

1

10

\*D3065-041\*

Step Leg Assembly Hi

\*\*

B 78798 (x10) Ac 12.04.23

## Location

## Loc Qty

## Loc Code

WA

44

66149

0

78799

40

79336

1

79419

3

D3067-1

Manufactured No

180

Each

178.0000

1

10

\*D3067-1\*

End Plate

\*\*

12.04.25

## Location

## Loc Qty

## Loc Code

WA

152

78608

92

80881

60

WA016

26

67582

2

68214

1

79607

23

AN3-35A

Purchased

No

250

Each

147.0000

2

20

\*AN3-35A\*

3/4" Bolt

\*\*

182 12/21/06 12/4/08

## Location

## Loc Qty

## Loc Code

ST353

147

120187

47

120644

50

120717

50

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3235-1 Manufactured No

250 Each

145.0000

\*D3235-1\*

Mounting Lug

Location

Loc Qty

Loc Code

ST

145

78787

145

D3278-041 Manufactured No

250 Each

1.0000

\*D3278-041\*

Support Assembly

Location

Loc Qty

Loc Code

ST481

1

78794

1

AN960JD416 NAS1149D0463J Purchased No

250 Each

14.0000

\*AN960JD416\*

Washer

Location

Loc Qty

Loc Code

ST351

14

116289

14

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

\*AN960JD516\*

Washer

AN5-36A Purchased No

250 Each

162.0000

\*AN5-36A\*

Bolt

Location

Loc Qty

Loc Code

ST340

162

120187

112

120731

50

\*\* 2 20

19X B 81920

\*\* 1 10

3X B 83361

\*\* 16 160

162255

\*\* 4 40

1119717

\*\* 2 20

121430

14x 6x

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

D2618

Manufactured No

250

Each

304.0000

2

20

\*D2618\*

Bushing

## Location

## Loc Qty

## Loc Code

ST012

304

76130

2

78537

102

80474

200

D2230-3

Manufactured No

250

Each

187.0000

4

40

\*D2230-3\*

Lug

## Location

## Loc Qty

## Loc Code

ST480

187

53881

4

70973

1

80009

182

D2856-400

Manufactured No

250

f

202.0445

1.2

12

\*D2856-400\*

Abrasion Strip

## Location

## Loc Qty

## Loc Code

ST409

202.0445

63735

0.6696

68076

0.3149

71164

8.46

79551

192.6

cut (2) D2856-400-720 as per dwg

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Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

250

Each

3,226.000

\*\*

\*MS21042L3\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

3226

117441

16

117885

32

118451

5

118927

3

119017

2990

119075

180

Purchased

No

250

Each

1,367.000

\*\*

AN4-13A

\*AN4-13A\*

Bolt

## Location

## Loc Qty

## Loc Code

ST357

1367

119449

59

120187

408

120422

500

120770

400

Purchased

No

250

Each

1,622.000

\*\*

MS21042L5

\*MS21042L5\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

1622

116105

5

116548

43

117611

42

118179

32

119109

1500

March-12-12 4:42:51 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# .. Picklist Print

Page 7

March-12-12 4:42:51 PM

Work Order ID: 81299

\*81299\*

Parent Item: D350-591-312

\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

3,831.000

\*MS21042L4\*

Nut

\*\*

8

80

Location

Loc Qty

Loc Code

ST300

3831

117441

51

117601

157

118451

133

119017

200

119075

3290

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

\*AN960JD10\*

Washer

\*\*

4

80

40

MA1243

12/4/12

March-12-12 4:42:51 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>9P</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. E SHEET 1 OF 1
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**

07.06.04-*H*



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *81299 MCV*  
*12/03/13*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

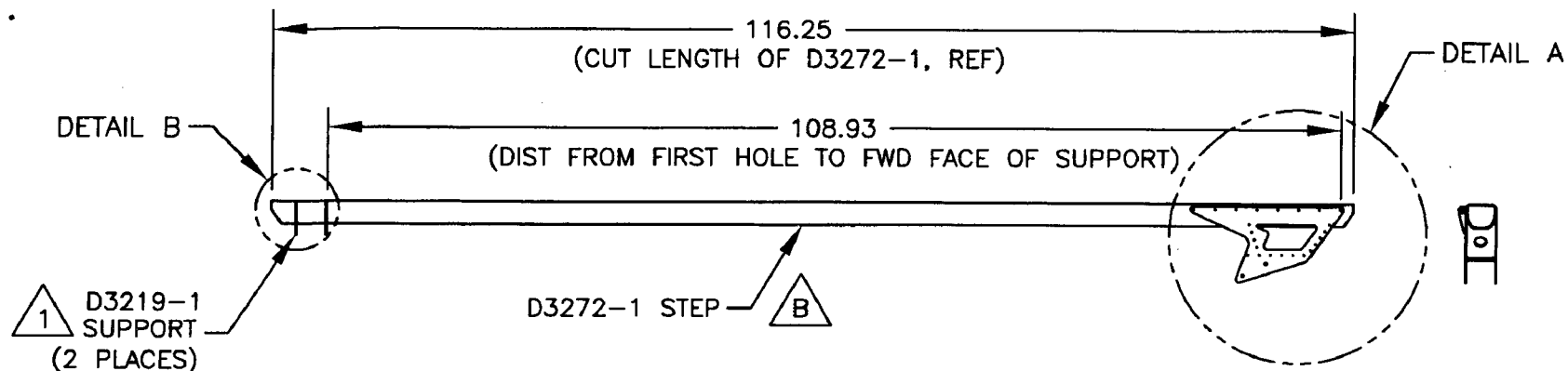
**NOTE:** Date & initial all entries



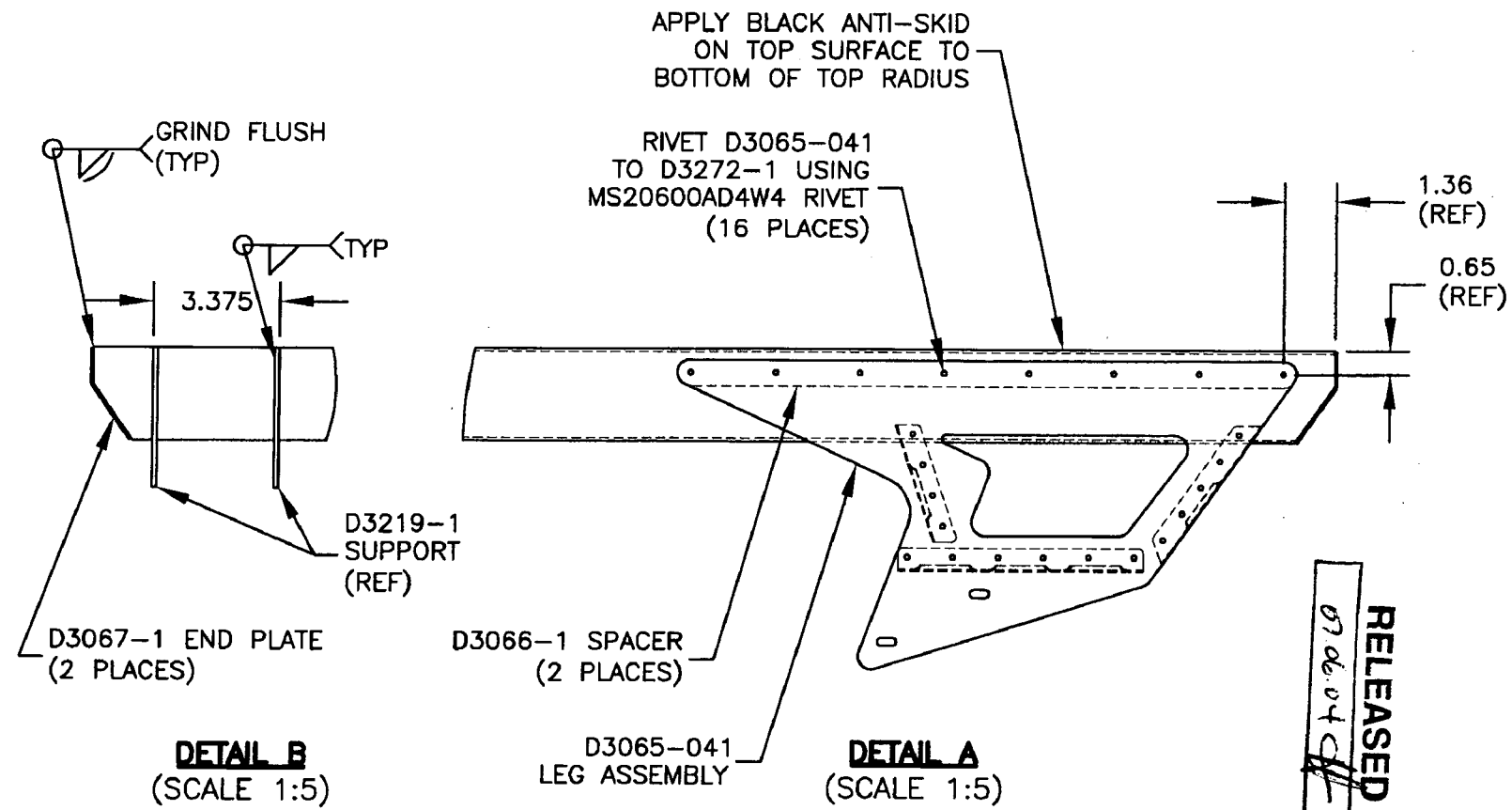
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. E
07.05.18	D3272	SHEET 2 OF 3
	TITLE	SCALE
	STEP ASSEMBLY, HI LONG	1:20

81299

RELEASED  
07.06.04



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

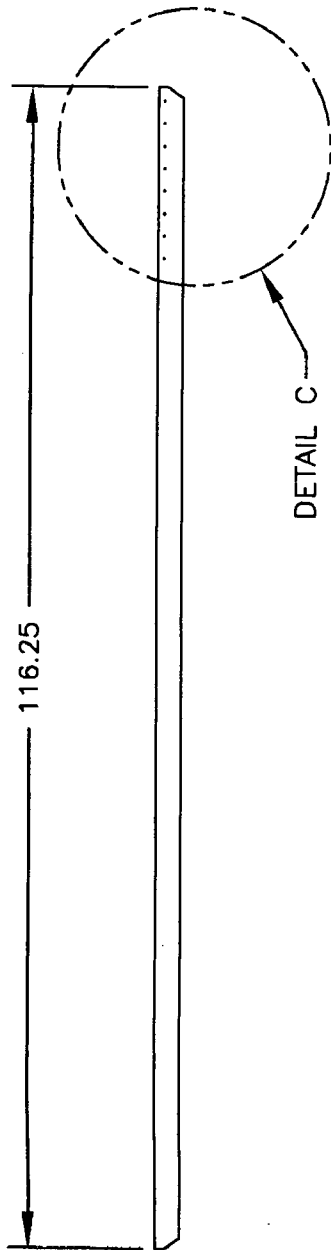
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

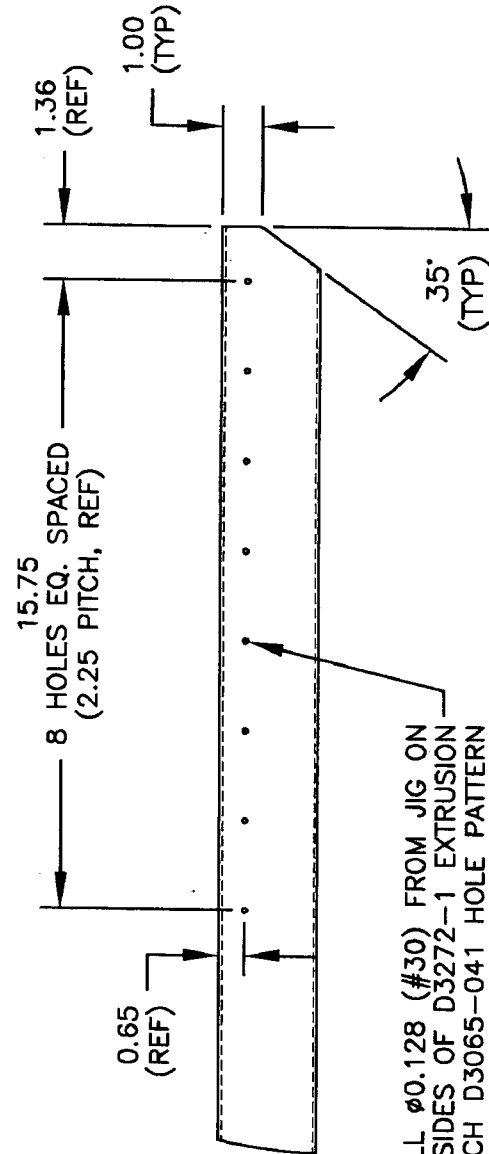


DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)

81299



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**

(SCALE 1:5)

RELEASED

07.06.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: **G**  
Date: 08.10.06